

Date: Wednesday, 9/12/2007 11:42:38 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ACCESS PANEL ASSEMBLY
Job Number : 34553	
Estimate Number : 13010	
P.O. Number : <u>N/A</u>	Part Number : D3245043
This Issue : 9/12/2007	Drawing Number : D3245 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u>	Drawing Revision : A
Previous Run : <u>N/A</u>	Material : <u>N/A</u>
Written By : <u>[Signature]</u>	Due Date : 10/5/2007
Checked & Approved By : <u>[Signature]</u>	Qty: <u>8</u> Um: Each
Comment : Est Rev : A New Issue 07-09-11 JLM Verified By: EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D32457	Gasket
-----	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Gasket

Batch: B23281 x 1mx, 35668 x 5mx mf 07-11-29 (6)

2.0	D32453	Door
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Door

Batch: B 34606 mf 07-11-29 (6)

3.0	235120009C3Y	STUD
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

STUD

Batch: m106198 mf 07-11-29 (48)

4.0	127H35	HALF GROMMET
-----	--------	--------------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

HALF GROMMET

Batch: m18245 mf 07-11-29 (48)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install Studs and Gromets as per Dwg D3245

3-Bond Gasket using 3M ADHESIVE as per Dwg D3245

mf 07-11-29 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/12/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/12/2007 11:42:38 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL ASSEMBLY

Job Number: 34553

Part Number: D3245043

Job Number:



Seq. #:

Machine Or Operation:

Description:

A/R 3M 13000/1300L ADHESIVE

Batch: M102890

MF 07-11-29 (6x)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/11/30 (x6)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST183

W

AS 07/11/30

(x6)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/12/04

Job Completion



W 07/12/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

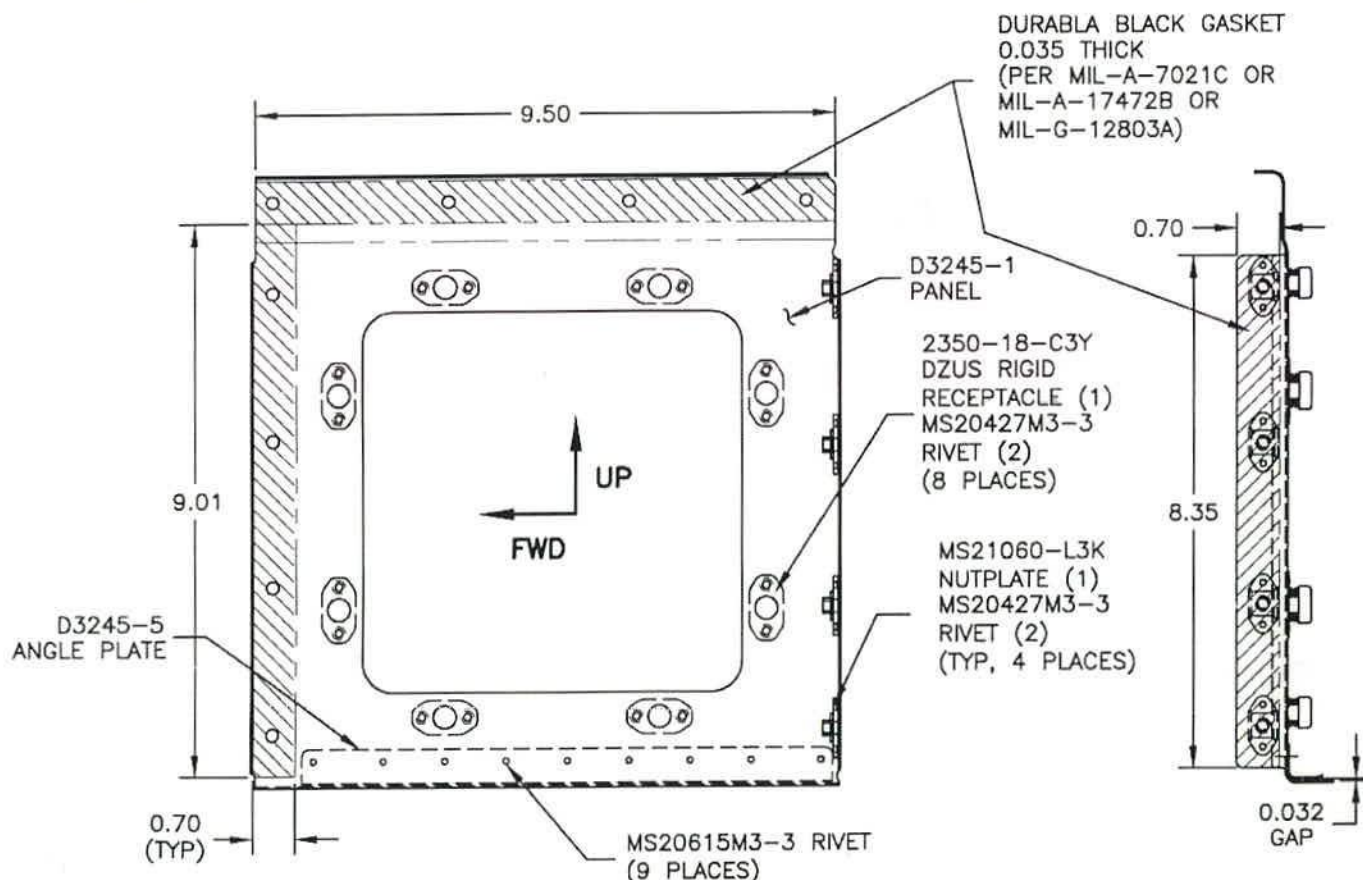
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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DATE 04.01.27	TITLE ACCESS PANEL ASSEMBLY		SCALE 1:3
A	04.01.27	NEW ISSUE	

RELEASED
04.04.21 *H*



D3245-041 ACCESS PANEL ASSEMBLY

D3245-041 NOTES:

- 1) FINISH: NONE
- 2) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) INSTALL GASKET USING 3M SCOTCH-GRIP P/N 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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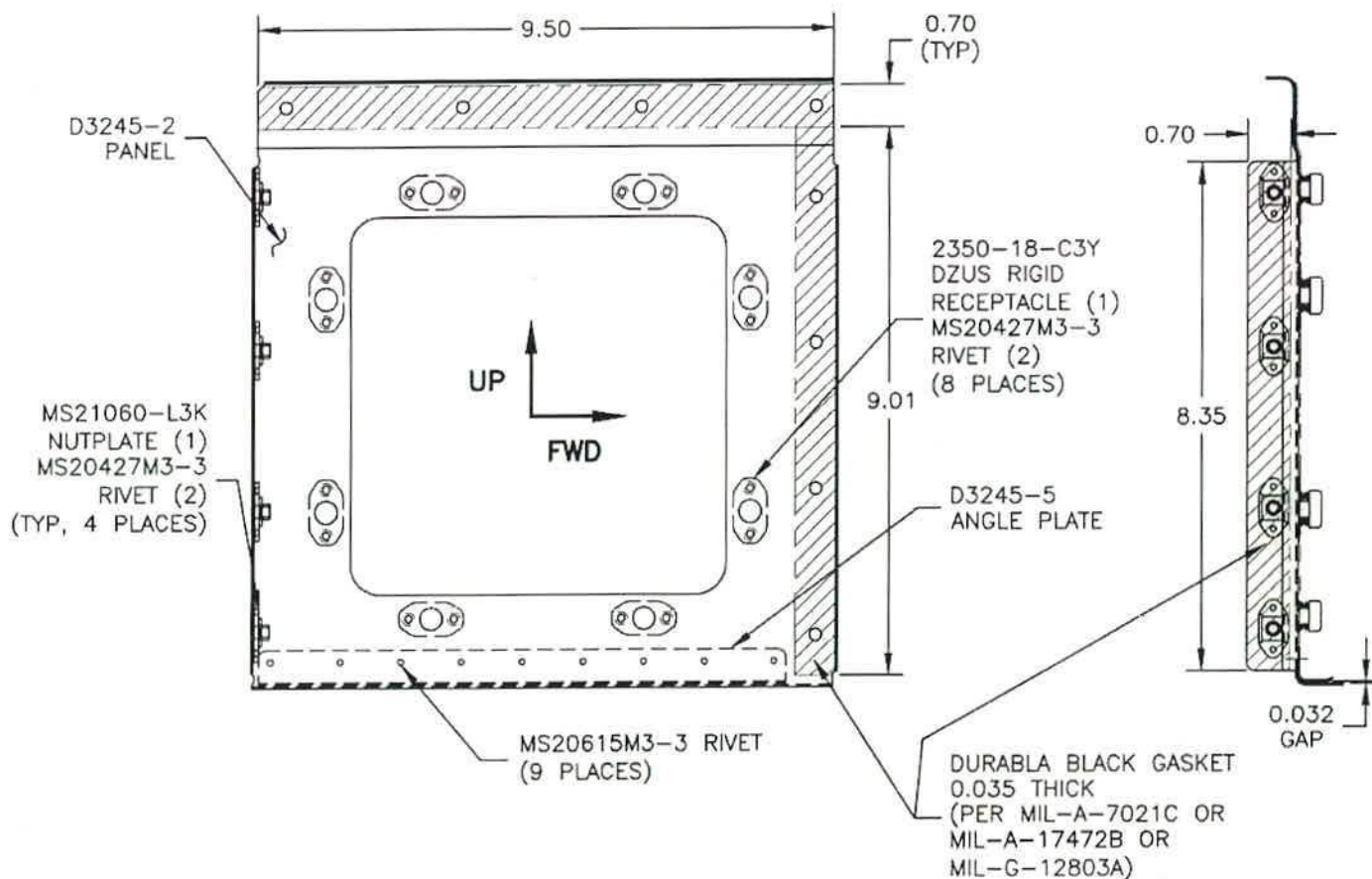
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DATE 04.01.27	TITLE ACCESS PANEL ASSEMBLY		SCALE 1:3

RELEASED
04.01.27



D3245-042 ACCESS PANEL ASSEMBLY

D3245-042 NOTES:

- 1) FINISH: NONE
- 2) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) INSTALL GASKET USING 3M SCOTCH-GRIP P/N 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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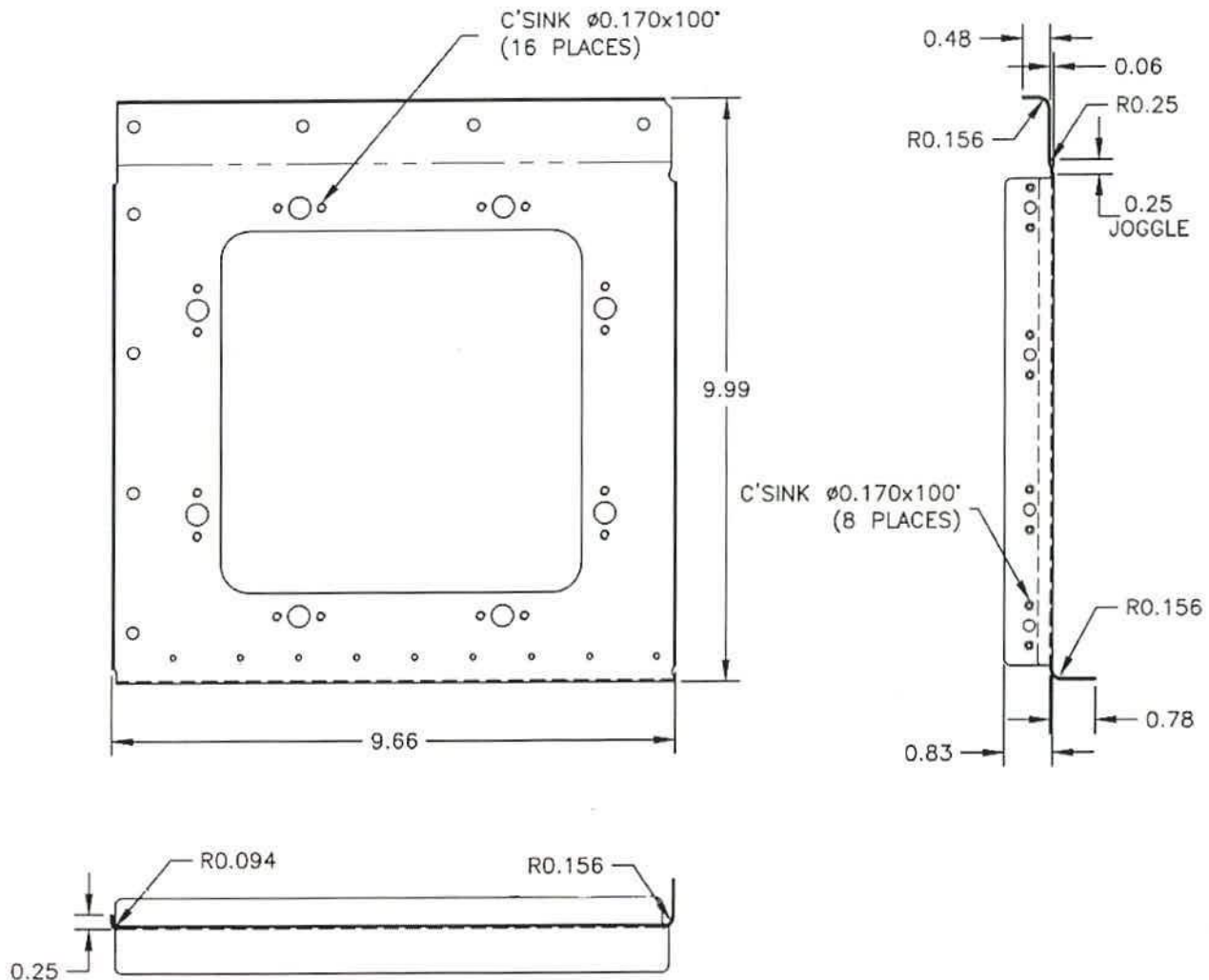
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DATE 04.01.27	TITLE ACCESS PANEL ASSEMBLY		SCALE 1:3

RELEASED
04.04.21



D3245-1 PANEL BEND DETAIL SHOWN
BEND D3245-2 PANEL OPPOSITE

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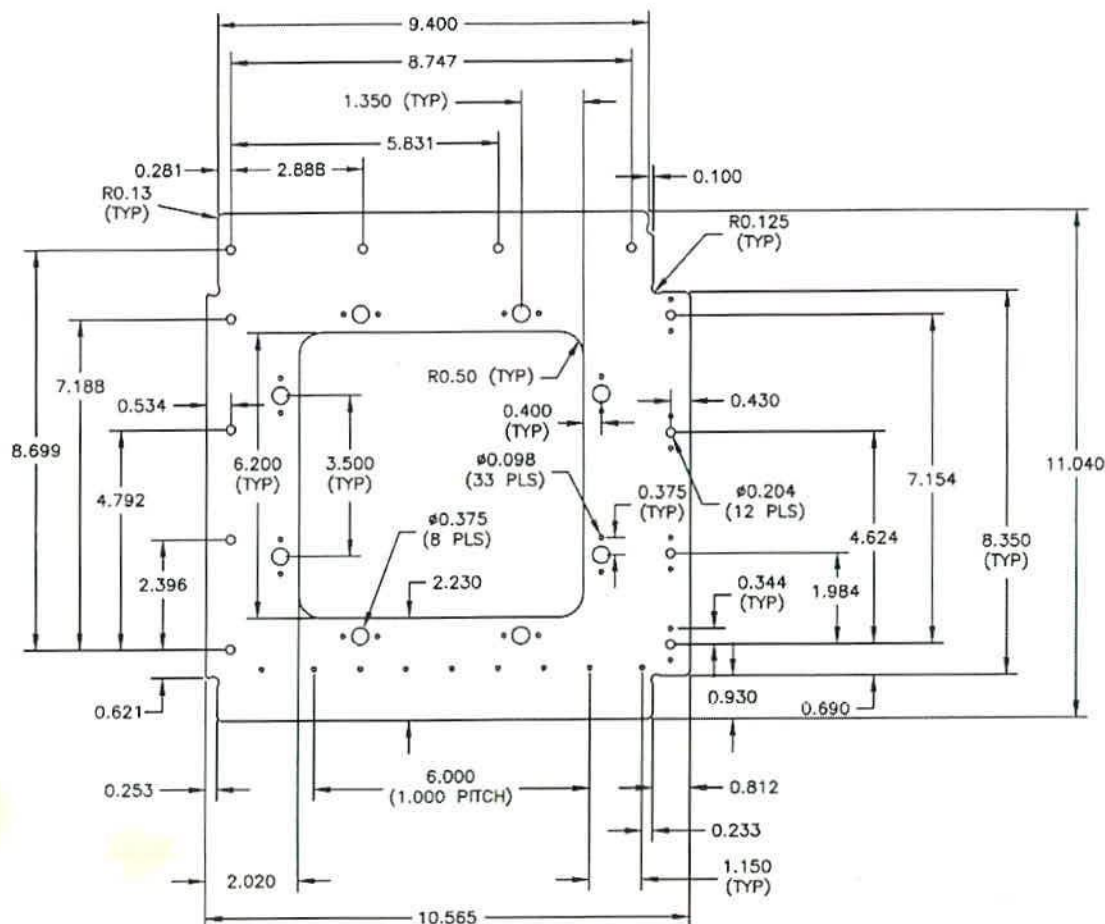
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DATE 04.01.27	TITLE ACCESS PANEL ASSEMBLY		SCALE 1:4

RELEASED
04.04.21 *[Signature]*



D3245-1/-2 PANEL FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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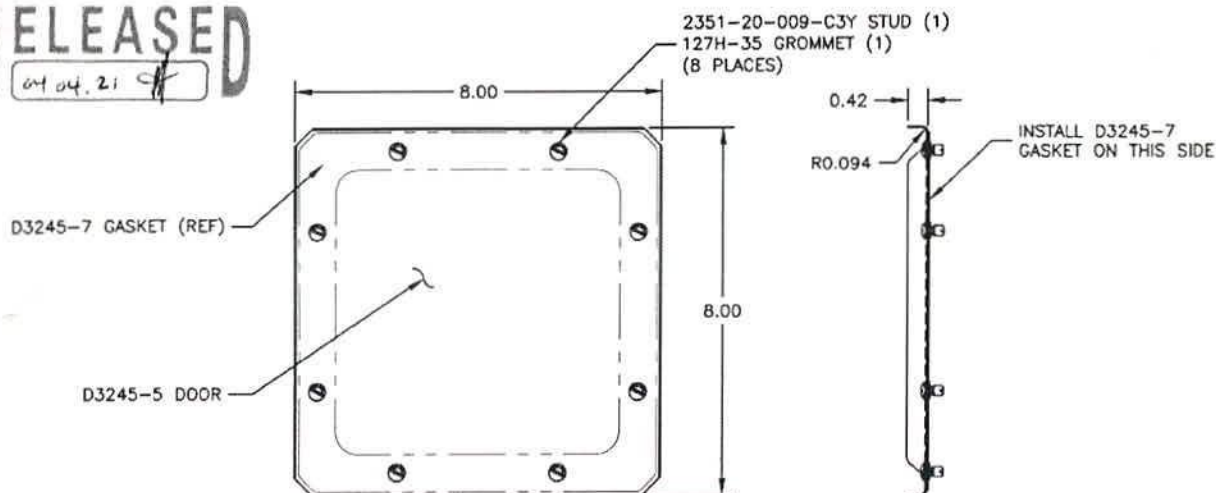
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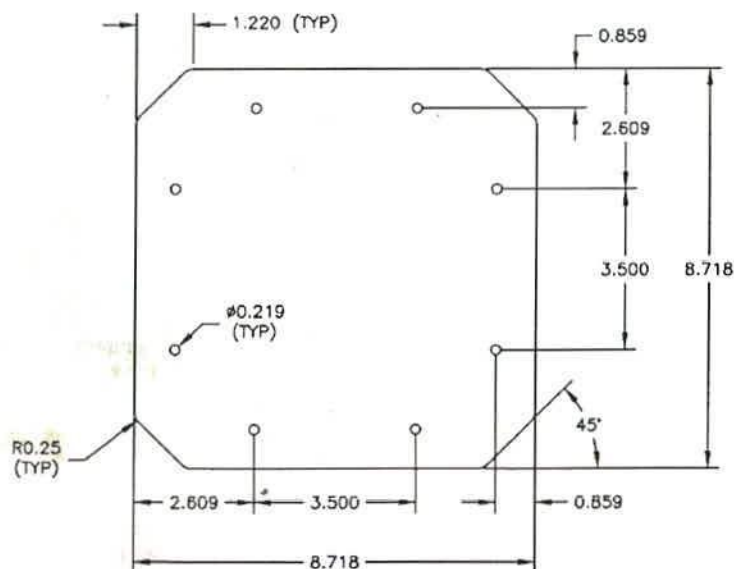


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DATE 04.01.27	TITLE ACCESS PANEL ASSEMBLY		SCALE 1:4

RELEASED
04.04.21 *ff*



D3245-043 DOOR ASSEMBLY

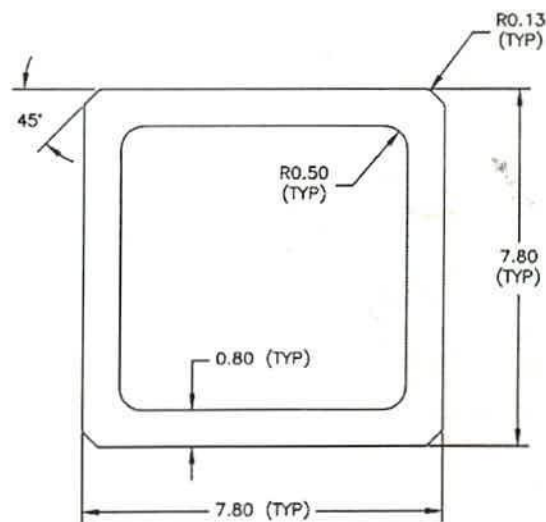


D3245-3 DOOR FLAT PATTERN

MATERIAL: AISI 304/316 SS 0.032 THICK
ANNEALED (REF. M304S22GA)

D3245-043 NOTES:

- 1) FINISH: NONE
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH THE MANUFACTURER'S INSTRUCTIONS
- 6) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 7) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER



D3245-7 GASKET

MATERIAL: DURABLE BLACK GASKET 0.035 THICK
(PER. MIL-A-7021C OR MIL-A-17472B
OR MIL-G-12803A)

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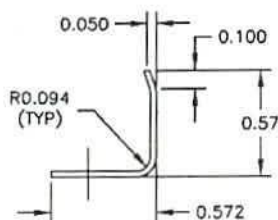
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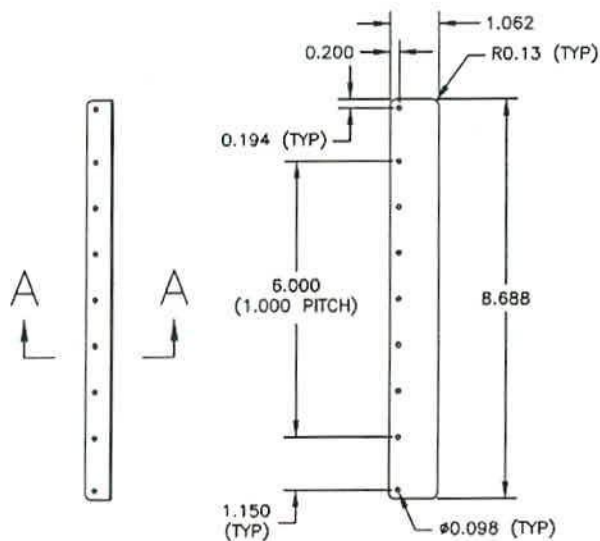


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040405 H



D3245-5 BEND DETAIL
VIEW A-A
SCALE 1:1



D3245-5 FLAT PATTERN

D3245-5 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK ANNEALED (REF. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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